

Work Order ID 52081

September 16, 2009 8:57:25 AM

Item ID: D3651-041
Revision ID: B
Item Name: Alt Base Assembly

Start Date: 9/16/09 Start Qty: 1.00
Required Date: 9/25/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID Operation
Description

Draw Nbr Revision Nbr
D3651 Rev B

100 Pick Kit
Packaging
Packaging

Memo

110 Small Fab
Small Fab
Small Fab

Memo

1-Assemble as per dwg D3651 2- Seal all mating surfaces and gaps using
Proseal 700 fire wall sealant as per dwg D3651 Batch: 1110624 3-install
D3651-1 using 3M high performance contact adhesive 1357 as per dwg
D3651 Batch: 1105625

120 QC5- Inspect part completeness to step on W/O
QC
Quality Control

Memo

Accept

Cust Item ID:
Customer:

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

27 808/12/10

80 09/12/10

80 09/12/10

① ②

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Item ID: D3651-041
Revision ID: B
Item Name: Aft Base Assembly

Accept



Setup Start



Stop



Start Date: 9/16/09 Start Qty: 1.00
Required Date: 9/25/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

GA

0.00

SS 09/12/10



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/10 JG
MK 09-12-10

Picklist Print

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3

Work Order ID: 52081

Parent Item: D3651-041RevB

Parent Item Name: Alt Base Assembly


Comments:

Start Date: 9/16/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3523-4-02		Purchased	No			100	Each	222.0000	58.0000			
												
RIVET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	222	
110914	1	
111127	21	
111359	100	
112278	100	

D3651-043RevB Manufactured No



Flange Weldment

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
45830	6	
110	Each	11.0000
		1.0000

D3651-11RevB Manufactured No



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
44675	5	
45452	6	
44679		

116 8809/12/10

~~116~~ 2 8809/12/10

22 8809/12/10
+

Picklist Print

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Work Order ID: 52081



Parent Item: D3651-041RevB

Parent Item Name: Aft Base Assembly

Start Date: 9/16/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3651-13RevB		Manufactured	No			110	Each	7.0000	1.0000			

D3651-13RevB



Outside Doubler

Warehouse
Location

Main Warehouse

ST

42117

44676

45453

Loc Qty

7

1

4

2

Loc Code

110

Each

7.0000

1.0000



D3651-1RevB



Gasket

Manufactured No

Warehouse
Location

Main Warehouse

ST

44674

45831

Loc Qty

7

2

5

Loc Code

JP 09/12/10

222 JB 09/12/10

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Shop Packet Print

Checklist Print

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Work Order ID: 52081

Parent Item: D3651-041RevB

Parent Item Name: Aft Base Assembly


Comments:

Start Date: 9/16/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3651-9RevB		Manufactured	No			110	Each	10.0000	1.0000			
<div>  </div>												
Inside Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
35847	1	
44677	5	
45451	4	

1
* 1

88 09/12/10

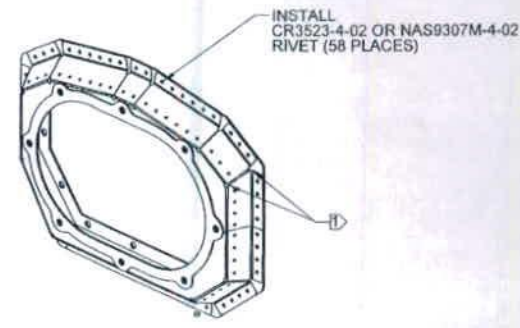
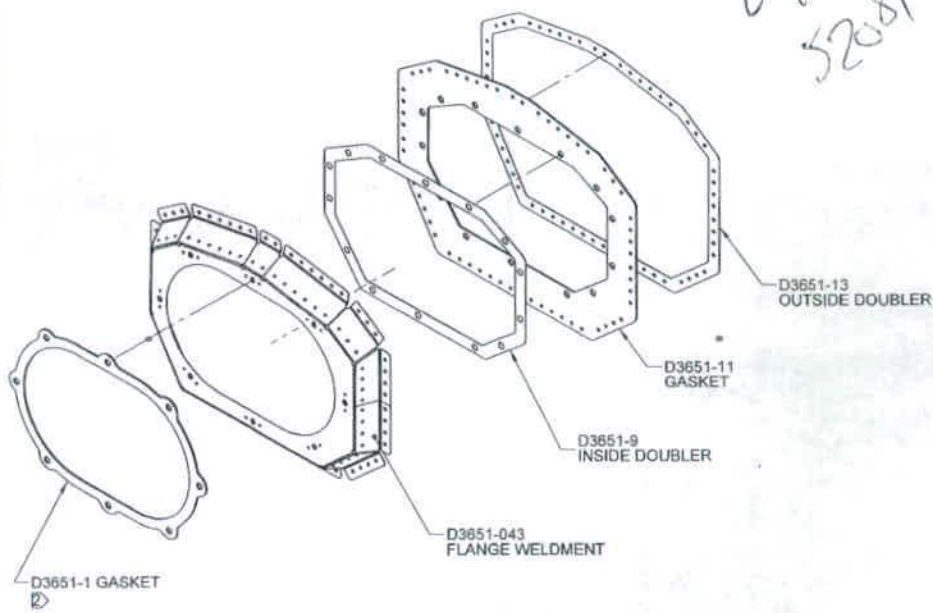
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Shop Packet Print

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WLO
52081



PART LIST

QTY	PART NUMBER	DESCRIPTION
041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

08.03.27/ND

D3651-041 AFT BASE ASSEMBLY

- D3651-041 NOTES:**
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	ND	D3651	SHEET 1 OF 9
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND UNCONTROLLED. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

